

20-8348



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3212-1

Job Sheet 206919



Part No: D3212-1

Job Qty: 10 pcs

Part Name: Replacement Interior Window For -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/20

Job Tracking No:

Due Date: 2/27/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev: A New Issue 05-11-09 JLM IPP Rev: B Water jet/ ecn798 06-05-08 EC IPP rev.C back on haas 07.04.09 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		2/27/20	0.17	1.00	Waterjet - Flow		20/02/14
110	HAAS 4 Axis - B4B	10 pcs		2/27/20	1.00	2.41	HAAS - 1 - B4B		JSD 20/2/14
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	10 pcs		2/27/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
QC 2 - 50									
QC 2 - 51									
QC 2 - 52									
QC 2 - 57									
QC 2 - 62									
					Plex 2/13/20 3:01 PM Dart.lajeunesse.marie				

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130 QC 8	10 pcs	2/27/20	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	20/2/24
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	20/02/25
				QC 8 - 17	
140 Small Fab - 2 - B4B	10 pcs	2/27/20	0.00 2.36	QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
150 QC 5	10 pcs	2/27/20	0.00 0.00	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	

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					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	10 pcs	2/27/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
170	QC 21 - SA	10 pcs	2/27/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - 1-Cut blanks. Descriptions: 110 - (HAAS CNC Vertical Machine) 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Small Fab) 1-Deburr if necessary 2-Install label as per Dwg D3212 3- polish abrasion scratches if necessary.. 4- Wrap in plastic wrap after inspection 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)						

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2728-1	Dart Logo Label Small	10 pcs (1 ea)	100-Waterjet - Flow - 1	5151992
MACRLICS.125	1/8" Polycast li Sheet	9.7450 sf (.9745 ea)	140-Small Fab - 2 - B4B	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	D2728-1	10	2,968	0
140-Small Fab - 2 - B4B	MACRLICS.125	10	1,265	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 246919
Description: Floor Window		Part Number: D3212-1
Inspection Dwg: D3212	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.7334	/		Haas 1	
6.367	+/-0.005	6.3662	/		"	
0.625	+/-0.005	0.624	/		"	
Ø0.156	+0.005/-0.001	0.156	/		Pin	
R0.25	+/-0.030	0.25	/		Radius Gauge	
8.150	+/-0.005	8.148	/		Haas 1	
3.750	+/-0.005	3.750	/		"	
0.313	+/-0.010	0.311	/		"	
15.14	+/-0.030	15.148	/		Vernier	
12.520	+/-0.005	12.518	/		Haas 1	
6.260	+/-0.005	6.259	/		"	
1.312	+/-0.005	1.311	/		"	
0.313	+/-0.010	0.311	/		"	
3.750	+/-0.005	3.75	/		"	
8.150	+/-0.005	8.148	/		"	
8.462	+/-0.005	8.463	/		"	
9.09	+/-0.030	9.099	/		Vernier	

Measured by: JBD
Date: 20/2/24

Audited by: Jmk
Date: 20/02/25

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	12.02.01	Dwg Rev updated	KJ	



Container No: S255925



Part: D3212 - 1

Job No: 206919

Serial No/Batch: S255925

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 02/14/20

Entered: TR Date: AUG 24 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8343

Route update only ☐

Job: <u>206919</u> Part No. <u>D3212-1</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date: <u>FEB 28 2020</u>		Sequence #: <u>150</u>		QTY Affected: <u>1 of 10</u>		MRB (QSI042) DAS 9 J-89 <u>20-8-6</u>																													
Description Work Order Deviation <u>-scratches in window and marks of rubbing</u>				Disposition <u>Scrap no replace</u>		Completed By DAS 58 J-89 <u>FEB 28 2020</u> Lead hand / Supervisor DAS 30 J-89 <u>FEB 28 2020</u> QC / QA Coordinator DAS 9 J-89 <u>20-8-6</u>																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☒ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☒ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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